

IN THE CLAIMS:

This listing of claims will replace all prior versions and listings of claims in the application.

Please amend claims 1-4 and 14-18 as follows:

Listing of Claims:

Claim 1 (Currently amended): A metal member to be cast-wrapped by a metal cast article, wherein said metal member to be cast-wrapped has an extruded ~~irregular-upset~~ roughened surface defining tears producing irregularly formed projections ~~projected~~ which project from said surface, wherein a maximum width of said projections at a tip end portion is wider than a maximum width of the projections at a base portion thereof.

Claim 2 (Previously presented): A metal member to be cast-wrapped as claimed in claim 1, wherein at least a part of said tip end portion of each of said projections is formed in a tapering sharp sectional shape.

Claim 3 (Currently amended): A metal member to be cast-wrapped as claimed in claim 1 or 2, wherein said extruded, roughened surface is arranged as elongated mutually spaced ~~metal member to be cast-wrapped is an extruded member having smooth surface portions directed in~~ extending parallel to a direction of extruding of the member and ~~irregular projections disposed between said~~ wherein elongated smooth, unroughened surface portions said irregular projection- defining upsets being formed when said metal member is extruded are disposed between, and extend

parallel to, said roughened surface portions.

Claim 4 (Currently amended): A metal member to be cast-wrapped as claimed in claim 3, wherein a side of each of said ~~irregular~~ irregularly formed projections ~~[[near]]~~ facing an extrusion starting end is wide and high, and a side of each of said ~~irregular~~ irregularly formed projections ~~[[near]]~~ facing an extrusion completing end is narrow and low.

Claim 5 (original): A metal member to be cast-wrapped as claimed in claim 1 or 2, wherein said metal member to be cast-wrapped is a hollow cylindrical body.

Claim 6 (Withdrawn): A cylindrical metal member to be cast-wrapped, wherein said cylindrical metal member has an outer surface formed with projections, said projections are arranged axially in rows and arranged circumferentially at regular intervals through grooves, and tip end portions of said projections are bent laterally.

Claim 7 (Withdrawn): A cylindrical metal member to be cast-wrapped, wherein said cylindrical metal member has an outer surface formed with projections, said projections are arranged axially in rows and arranged circumferentially at regular intervals through grooves, and tip end portions of said projections are bent in axial direction.

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Claim 8 (Withdrawn): A cylindrical metal member to be cast-wrapped as claimed in claim 6 or 7, wherein said projections are arranged axially at irregular intervals and are not aligned circumferentially.

Claim 9 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped by a metal cast article having an outer surface with projections; comprising:

preparing a die having an inner peripheral surface formed with longitudinal grooves of depth H and width W, relation between a maximum depth H_{MAX} and a minimum width W_{MIN} of the groove being set as $H_{MAX} / W_{MIN} \geq 1.5$;

inserting a cylindrical metal material in said die; and

hot-extruding said cylindrical metal material to obtain the cylindrical metal member to be cast-wrapped having an outer surface with projections.

Claim 10 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped as claimed in claim 9, wherein said minimum width W_{MIN} of said groove is set as $W_{MIN} \leq 1.3$ mm.

Claim 11 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped as claimed in claim 9 or 10, wherein relation between a minimum inner diameter d and a total inner peripheral length L of a cross-section of said die is set as $L / d \pi \geq 1.5$.

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Claim 12 (Withdrawn): A cylindrical metal member to be cast-wrapped as claimed in claim 6 or 7, wherein said metal member to be cast-wrapped is a hollow cylindrical body.

Claim 13 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped as claimed in claim 9 or 10, wherein said metal member to be cast-wrapped is a hollow cylindrical body.

Claim 14 (Currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 1, wherein said metal member is a cylindrical member that has an outer surface ~~containing~~ having said extruded ~~upsets forming irregular surfaces defining~~ roughened surface defining said tears producing said irregularly formed projections extending from said surface, said projections being ~~provided in mutually adjoining disposition and, all of said projections being~~ arranged axially of the cylindrical member in rows and at intervals spaced circumferentially about the cylindrical member.

Claim 15 (Currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein each of said projection-defining ~~upsets~~ tears has a tip end portion bent laterally.

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Claim 16 (Currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein unroughened grooves are provided between circumferentially ~~adjoining~~ adjacent rows of projection-defining ~~upsets~~ tears.

Claim 17 (Currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein said roughened surface contains rows of projection defining ~~upsets~~ are tears arranged at regular intervals ~~in said rows~~ about the circumference of said cylindrical member.

Claim 18 (Currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein said projection-defining ~~upsets~~ tears are arranged at irregular intervals in said rows and generally out of circumferential alignment.

Claim 19 (Previously presented): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein said cylindrical member is hollow.